

Work Order ID 86359

June-27-12 3:45:40 PM

86359

Page 1

Item ID: D2171

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clamp

Stop ***NS2***

Start Date: 27/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/28

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2171

Rev D

100

0.00

100

PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

304 .063

Dwg Rev: 8

Prog Rev: 8

2-Deburr if necessary

20 0 Jun 12-6-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20 0 Jun 12-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Form as per dwg	0.00							
130	Small Fab								
Brake NC	Memo	0.00							
Brake NC	1- remove press and machine marking as necessary								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

S. Zlobetz

cont
(720)

20

S
12/07/09

cont
(476)

S. Zlobetz

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>457</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

(20) 12-1-10SD

CK 12/7/10
MF 12-07-10

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NOTE: Date & initial all entries

Picklist Print

June-27-12 3:45:44 PM

Page 1

Work Order ID: 86359

86359

Parent Item: D2171

D2171

Parent Item Name: Clamp

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 11.04.26 now made in house DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	0.0000	0.0258	0.543158			

M304S16GA

304/316 Sheet .063

**

Jm 12-6-29

122245

122245

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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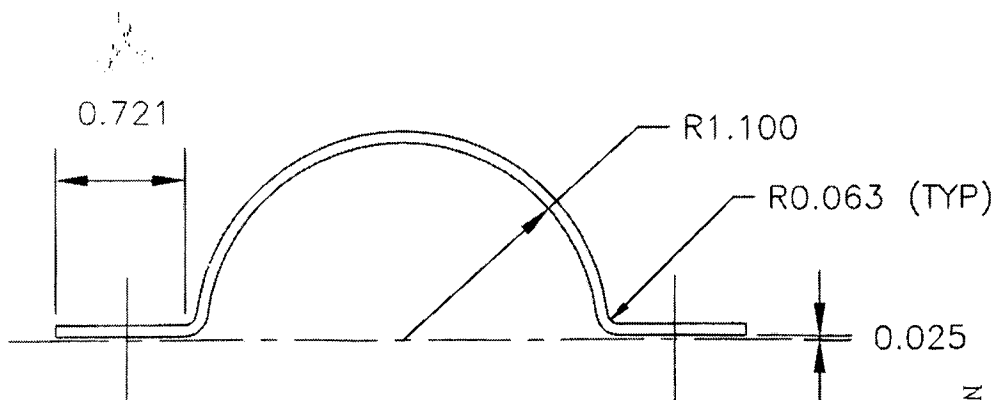
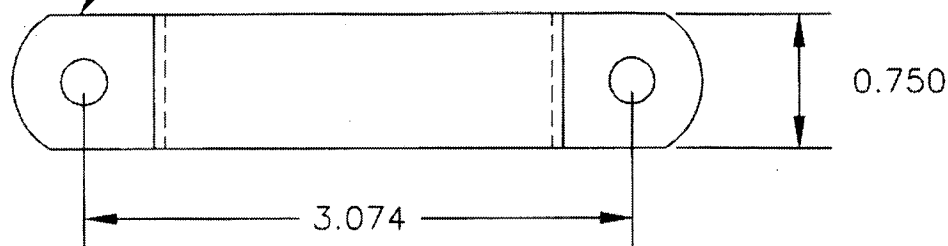
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY DA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2171	REV. D SHEET 1 OF 1
DATE 99.03.08		TITLE CLAMP	SCALE 1:1
B	96.01.29	REDRAWN	
C	97.05.14	RADIUS CHANGED, CUSHION ADDED	
D	99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4.888	

RELEASED
99.03.11 KE

PUNCH ENDS PER SPEC
CONTROL DRAWING D2727



MATERIAL: 304/316 SS 0.063 THICK
FLAT LENGTH: 4.968 END-END
4.158 HOLE-HOLE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80359/1125
12/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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